Date:

Tuesday, 23/12/2008 1:22:44 PM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 44295 : 10608

Estimate Number P.O. Number

This Issue

: 23/12/2008

: NC

First Issue : // **Previous Run**

: 34752

Type

: PURCHASED PARTS

Part Number

Drawing Name

: D2655

: RING

Drawing Number

: D2655 REV B : N/A

Project Number

: B **Drawing Revision** Material

Due Date

: 05/01/2009

Qty:

20 Um: Each

Written By

Prsht Rev.

Checked & Approved By

Comment

: Est. D 00.06.22

Removed P/O for powder coat EC

Est Rev:E Now on Waterjet 06-10-04 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M1018B400X250



1018 bar 4.00 x .250

Comment: Qty.:

0.2835 f(s)/Unit Total:

5.6700 f(s)

1018 ASTM A36 .250" thk bar x 4.0"

Batch: 10410 2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2655

Dwg Rev: Prog Rev:

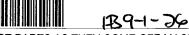
26-1-PAI



2-Deburr if necessary

3.0

QC2





PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

.1-Tumble - .030 Radius W A O 2-Deburr any rough edges after tumbling



Dart Aerospace	Lta
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W/O:		WORK ORDER CHANGES									
DATE	STEP	:	PR	OCEDURE CHAN	IGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		. !					16.			·	
) <u>1</u>	
Part No	:		PAR #:	Fault Categ	ory:	_ NCR:	Yes I	No DQ	A:	_ Date: _	
	Re	solution:	· · · · · · · · · · · · · · · · · · ·	Disposition	:	QA: N	/C Clo	sed:		Date: _	
NCR:				WORK ORDE	R NON-CONFORM	ANCE (NCR)		Sec.	1,477,444
DATE	STEP	Desc	cription of NC Section A	Initial Chief Eng	Initial Action Description		Section B on Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
1				Office Eng	Criter Eng		Date				
		:								,	
		į									

NOTE: Date & initial all entries

Date: √Tuesday, 23/12/2008 1:22:44 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: RING** Job Number: 44295 Part Number: D2655 Job Number: Seq. #: **Machine Or Operation: Description:** 6.0 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 7.0 POWDER COATING POWDER COATING m 109996 Comment: POWDER COATING Powder Coat per QSI 005 4.3.5.1 START TIME: **OVEN TEMPERATURE:** FINISH TIME: QC3 8.0 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 0 6 PACKAGING 1 9.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE W 89,0130 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E	Verification	Approval	Ammunual			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
						,	,	•		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44295
Description: Ring	Part Number:	D2655
Inspection Dwg: D2655 Rev: B	·	Page 1 of 1

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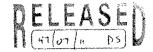
nspection Dwg	j: D2655 Re v	v: B				Page	e 1 of 1
	FIRS	T ARTICLE I	NSPECTI	ON CHE	CKLIST		•
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comr	nents
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easured by:	B	Audited by:			Prototype Ap	<u> </u>	N/A
Date:	9-1-26	Date	olla	126		Date:	N/A
ev Date	Change				Rev	ised by	Approv
A 06.10.12	New Issue				KJ/J	LM A	_{/II/_

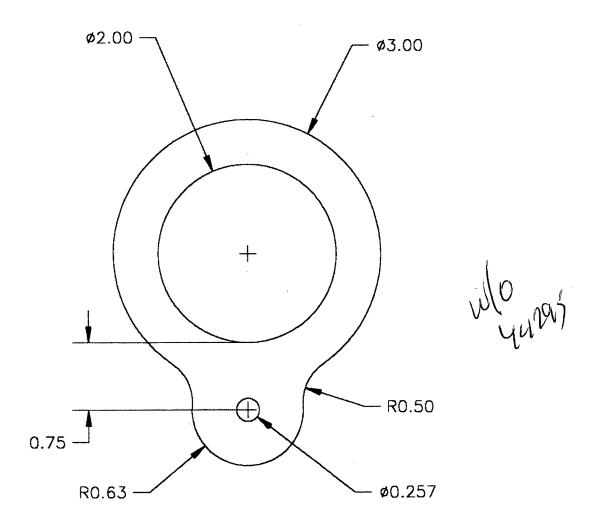
H-\EORMS\Ouality	Assurance\approved QA\FAI revD	





DESIG	NOY	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECH	(ED	APPROVED	DRAWING NO. REV. B
	4-)	1 1/4	D2655 SHEET 1 OF 1
DATE			TITLE SCALE
97:0	7:07		RING 1:1
Α		97:03:25	NEW ISSUE
В		97:07:07	ADD ASTM A36 TO MAT. SPEC.





NOTE: DEBURR ALL SHARP EDGES

MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	: !	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
R	lesolution:		Disposition:	QA: N/C Closed:	Date:
Resolution:		WO	RK ORDER NON-CONFORM	ANCE (NCR)	

_		Description of NC		•	Corrective Action Section E	3	Verification		
DATE	STEP	i	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries